

If possible, the jig should be drawn full size, as it is a great deal easier to obtain the correct proportions when so doing. Of course, in many cases, it will be impossible to draw the jigs full size. In such cases the only thing to do is to draw them to the largest possible regular scale. Every jig draftsman should be supplied with a set of blueprints containing dimensions of standard screws, bolts, nuts, thumb-screws* washers, wing-nuts, sliding points, drills, counterbores, reamers, bushings, etc.; in short, with blueprints giving dimensions of all parts that are used in the construction of jigs, and which are, or can be, standardised. It should be required of every designer and draftsman that he use these standards to the largest possible extent, so as to bring the cost of jigs down to as low a figure as possible.

It is highly desirable, for the obtaining of best results, that, before starting on the drawing, the draftsman who is to lay out the jig should consult the foreman who is initially going to use the jig. Oftentimes this man will be the best idea for the making of the jig or tool. The combined experience of the draftsman and the foreman will produce a much better tool than could either of them alone.

As a jig drawing, in most cases, in only a few instances, at most only a very few times, it is not advisable to take a blueprint from the drawing, but, as a rule, the drawing itself may be used to advantage. If, however, if given out in the shop directly as it comes from the drafting board, it is likely to become soiled, so that, after it would be impossible to make out the meaning of the drawing. For this reason jig drawings should be made on preferably of brown color, which is not as good as white paper; and in order to prevent the drawing from being torn, it should be mounted on strawboard, and held in place by thin wooden strips, nailed to the board, as follows:

cover the drawings with a thin rmti of lliry
are
sent out into the shop. When thin k «It>iti,% rilrl
and Muck
may be washed off tiimlly; ami the itM-lf may Iw
wished
off by wood alcohol, when the is returm-d tu the
draft-
ing-room. The drawing, after *h*
then